

Work Order ID 47935A

Friday, June 26, 2009 9:00:31 AM



Page 1

Item ID:	D2724-042	Accept		Setup	Start	
Revision ID:	C				Stop	
Item Name:	206L Step Assembly					
Start Date:	7/15/2009	Start Qty:	4.00		Cust Item ID:	
Required Date:	8/3/2009	Req'd Qty:	4.00		Customer:	
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2724	Rev C

100		0.00							
-----	--	------	--	--	--	--	--	--	--

	Large Fab								
Large Fab		0.00							
Large Fab	Memo								
	Cut D2724-2 using D2622 extrusion as per Dwg D2724 <input type="checkbox"/> Deburr and bevel ends for welding								
	<u>B# 46910</u>								
	SAD 09-07-01 (4)								

110		0.00							
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	Large Fab								
Large Fab		0.00							
Large Fab	Memo								
	Weld end cap and lugs as per Dwg D2724 using Jig DT8898 followed by Jig <input type="checkbox"/>								
	DT (One End Only) <input type="checkbox"/> A/R AL ROD Batch: <u>M110130</u> <input type="checkbox"/> Grind								
	end cap welds flush								
	<u>M110972</u>								

120		0.00							
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	QC9- Inspect visual per QSI004- Fusion Welds								
QC		0.00							
Quality Control	Memo								

DD 09-07-14

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Item ID: D2724-042

Accept

Setup Start

Revision ID: C

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Item Name: 206L Step Assembly

Start Date: 7/15/2009 Start Qty: 4.00

Cust Item ID:

Required Date: 8/3/2009 Req'd Qty: 4.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

140

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

150

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control



⇒ 809102/14 X4AH

09.07.14 4

SAD 09-07-14 4

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Item ID: D2724-042

Accept

Setup Start

Revision ID: C

Stop

Item Name: 206L Step Assembly

Start Date: 7/15/2009 Start Qty: 4.00

Cust Item ID:

Required Date: 8/3/2009 Req'd Qty: 4.00

Customer:




Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160  Large Fab	Large Fab	0.00							
Large Fab	Memo Inspect for foreign object per QSI 024 <input type="checkbox"/> Weld Remaining end cap as per Dwg D2724 using Jig DT8898 followed by Jig <input type="checkbox"/> DT <input type="checkbox"/> A/R AL ROD Batch: <u>M110130</u> <input type="checkbox"/> Grind end plate flush.	0.00							
170  QC	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
Quality Control	Memo	0.00							
180  QC	QC5- Inspect part completeness to step on W/O	0.00							
Quality Control	Memo	0.00							



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Item ID: D2724-042 Accept  Setup Start 
Revision ID: C Stop 
Item Name: 206L Step Assembly
Start Date: 7/15/2009 Start Qty: 4.00  Cust Item ID:
Required Date: 8/3/2009 Req'd Qty: 4.00  Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start 
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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190  HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00	UMO 09/07/15 (x4)						
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200  Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum Pressure WASH Memo START TIME: 2:45pm FINISH TIME: 3:15pm OVEN TEMPERATURE: 320°F	0.00 0.00	UMO 09/07/15 (x4) all 09-07-15 x4						
---	--	------------------	-----------------------------------	--	--	--	--	--	--

210  QC Quality Control	QC3- Inspect Part Finish Memo 09-07-16 (4)	0.00 0.00							
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Revision ID:	C				Stop	
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Start Date:	7/15/2009	Start Qty:	4.00		Cust Item ID:	
Required Date:	8/3/2009	Req'd Qty:	4.00		Customer:	
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
220	Pressure Wash per QSI0054.3 <i>Wing Walk</i> <i>09/07/15</i>	0.00							
	Memo	0.00							
HandFinish									
Hand Finishing	<i>BACK: m11013</i>								
230	QC3- Inspect Part Finish	0.00							
	Memo <i>BR 09-07-16</i>	0.00							
QC									
Quality Control									
240	Identify as per dwg & Stock Location:	0.00							
	Memo	0.00							
Packaging									
Packaging									

PPP 47935 9/7/21 Scl (40)

Work Order ID 47935A

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Item ID: D2724-042

Accept



Setup Start



Revision ID: C

Stop



Item Name: 206L Step Assembly

Start Date: 7/15/2009 Start Qty: 4.00



Cust Item ID:

Required Date: 8/3/2009 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

250

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/07/22

MF 09-07-22

Picklist Print

Page 1

Friday, June 26, 2009 9:00:31 AM

Work Order ID: 47935A

Parent Item: D2724-042RevC

Parent Item Name: 206L Step Assembly





Start Date: 7/15/2009

Required Date: 8/3/2009

Comments:

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3458-3RevA 		Manufactured	No			100	Each	0.0000	8.0000			
Step Mounting Plate D2622-120CRevC1 		Manufactured	No			110	Each	0.0000	4.0000			
Step Extrusion D2734RevC 		Manufactured	No			110	Each	0.0000	8.0000			
Step End Plate D3458-1RevA 		Manufactured	No			110	Each	0.0000	8.0000			
Step Mounting Plate												

344002 09-07-13

B 46910 SPD 09-07-13

343535 09-07-13

344002 09-07-13

Date: Wednesday, 13/05/2009 11:29:00 AM
 User: Julie Dawson

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: 206L /407 STEP ASSY, RH
Job Number	: 47935A		
Estimate Number	: 11703		
P.O. Number	:	Part Number	: D2724042
This Issue	: 13/05/2009	S.O. No.	:
Prsht Rev.	: NC	Drawing Number	: D2724 REVC
First Issue	: / /	Project Number	: N/A
Previous Run	: 43032A	Drawing Revision	: C
	Type : LARGE FAB ASSY	Material	:
Written By	: <u>JUD 09.05.13</u>	Due Date	: 29/05/2009
Checked & Approved By	: <u>JUD 09.05.13</u>	Qty:	4 Um: Each
Comment	: Est Rev:E As Per Ecn 766 06-01-06 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D2622120C	Step Extrusion
-----	-----------	----------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Qty	Part #	Description	Batch:
-----	--------	-------------	--------

1	D2622-120C	Extrusion	<u>B26910</u>
---	------------	-----------	---------------

Check Material for any Dents or Defects

SAD 09-07-01

2.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
-----	-------------	------------------------------

**Comment:** LARGE FABRICATION RESOURCE 1

Cut D2724-2 using D2622 extrusion as per Dwg D2724

Deburr and bevel ends for welding

SAD 09-07-01

3.0	D2734	Step End Plate
-----	-------	----------------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

206 Step Endplate

Pick:

Qty	Part Number	Description	Batch
2	D2734	End Cap	<u>B43535</u>

SAD 09-07-12

4.0	D34581	Step Mounting Plate
-----	--------	---------------------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
2	D3458-1	Plate	<u>B44002</u>

SAD 09-07-12

Date: Wednesday, 13/05/2009 11:29:00 AM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L /407 STEP ASSY, RH

Job Number: 47935A

Part Number: D2724042

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D34583

Step Mounting Plate



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty Part Number
2 D3458-3

Description
Plate

Batch

344003

PK 09.07.12 4

6.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Weld end cap (One End Only) and lugs as per Dwg D2724 using Jig DT8898 followed by Jig

A/R AL ROD Batch: M110130
M110992

Grind end cap welds flush

PK 09.07.14 4

PK 09.07.14 4

7.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

AD 09.09.14

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

80702/4 (x42H)

9.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

PK 09.07.14 4

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

SAD 09-07-14 (4)

11.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Inspect for foreign object per QSI 024

Weld Remainig end cap as per Dwg D2724 using Jig DT8898 followed by Jig

PK 09.07.14 4

PK 09.07.14 4

Date: Wednesday, 13/05/2009 11:29:00 AM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L/407 STEP ASSY, RH

Job Number: 47935A

Part Number: D2724042

Job Number:



Seq. #:

Machine Or Operation:

Description :

DT

A/R AL ROD Batch: M110130

Grind end plate flush.

Handwritten: 09.07.14

12.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

Handwritten: 09.07.15 (4)

13.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Handwritten: 09/07/15 (4) (24210)

14.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Touch up Alodine

Handwritten: UMD 09/07/15 (x4)

15.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

Handwritten: M112148 Pressure Wash

Handwritten: UMD 09/07/15 (x4)

START TIME:

Handwritten: 2:45pm

OVEN TEMPERATURE:

Handwritten: 320°C

FINISH TIME:

Handwritten: 3:15pm

Handwritten: 09-07-15 (x4)

16.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

Handwritten: BR 09-07-16 (4)

17.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: Wing Walk as per Dwg D2724 and QSI 00 5 4.4

Handwritten: M11013

Handwritten: UMD 09/07/16 (x4)

18.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

Handwritten: BR 09-07-16 (4)

Date: Wednesday, 13/05/2009 11:29:00 AM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L /407 STEP ASSY, RH

Job Number: 47935A

Part Number: D2724042

Job Number:



Seq. #:

Machine Or Operation:

Description :

19.0



PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

20.0



QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



RELEASED

05.11.14

APPLY BLACK
ANTI-SKID ON
- TOP SURFACE
TO BOTTOM
OF TOP RADIUS

— REFER TO STEP
END DETAIL

D2724-1
MAKE FROM EXTRUSION D2622-107


ROUND CORNER OF EXTRUSION TO
MATCH BEND RADIUS OF END PLATE

D2734 END PLATE

TYPICAL STEP END DETAIL
NOT TO SCALE

MEASURED BEFORE END CAPS WELDED IN PLACE

81.11
DISTANCE TO
PLATE CENTER
LINES AT TOP
OF STEP

FWD → 

D2724-042 RH STEP ASSEMBLY (OPPOSITE)

D2721-041/-042 STEP ASSEMBLY PARTS LIST

QTY - 041	QTY - 042	PART NUMBER	DESCRIPTION
X		D2724-041	LH STEP ASSEMBLY
	X	D2724-042	RH STEP ASSEMBLY
1	1	D2622-107	EXTRUSION
2	2	D2734	END PLATE
2	2	D3458-1	PLATE
2	2	D3458-3	PLATE

D2724-041/-042 STEP ASSEMBLY

- 1) MAKE FROM EXTRUSION D2622 TYPICAL S
2) WELD PER DART QSI 004 NOT
3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
APPLY BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
4) ALL DIMENSIONS ARE IN INCHES
5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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MEMORANDUM
FOR THE RECORD
SUBJECT TO AMENDMENT
UNCONTROLLED COPY
WITHOUT NOTICE
WORK ORDER
114354

WORK ORDER

DART AEROSPACE USA, INC.
PORT HADLOCK, WA

POKI MADLOCK, WA

DESIGN	KE	DRAWN BY	PH
CHECKED	MM	APPROVED	MM

DRAWING NO.

1

051271

SHEET 1 OF 1

DATE _____

TITLE

SCALE

A	97.12.04
---	----------

NEW ISSUE

1

B 98.10.19

REVISED TOLERANCES

C	05.09.19
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RE--DESIGN, ADD D3458-1/-3

10